Work Order ID 63714

November 10, 2010 12:36:38 PM

Item ID: DSI 9410-011 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Step Modification

Start Date: 11/10/10 **Start Qty:** 8.00 **Cust Item ID:**

Required Date: 11/15/10 **Req'd Qty:** 8.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr DSI 9410	**Revision Nbr** B								
100		0.00							
DC	**Memo**	0.00							
Document Control	Photocopy bluefile &type labels per PPP DSI 9410-011 CHG002								
110	Pick Kit	0.00							
Packaging	**Memo**	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
QC	**Memo**	0.00							
Quality Control									

for CL 10-11-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** **Date:** **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
Packaging									
Packaging	**Memo**	0.00							
	Identify and pack for shipping as per PPP DSI 9410-011 Location: 30 PPP rev: A								
140	QC21- Final Inspection - Work Order Release	0.00							
QC									
Quality Control	**Memo**	0.00							

10/11/11

11-10-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

November 10, 2010 12:36:37 PM

Work Order ID: 63714

Parent Item: DSI 9410-011

Parent Item Name: Step Modification

Start Date: 11/10/10 **Required Date:** 11/15/10

Start Qty: 8.00 **Required Qty:** 8.00

Comments: IPP RevA: New issue DD verified by:EC IPP rev:B as per dwg RevB DD
10.03.03 verified by:EC

Component Item ID / Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-15A Bolt		Purchased	No			110	Each	543.0000	8	64			
				Location			**Loc Qty**		**Loc Code**				
				ST			112						
					115374		112						
				ST358			431						
					114784		9						
					115108		22						
					115371		100						
					115936		300						
AN960JD416	NAS1149D0463J	Purchased	No			110	Each	24.0000	16	128			
Washer													
				Location			**Loc Qty**		**Loc Code**				
				ST300			24						
					113288		24						
D2732-030		Manufactured	No			110	Each	20.0000	4	~~32~~ 8 feet			
Rubber Cushion													
				Location			**Loc Qty**		**Loc Code**				
				ST409			20						
					63484		20						

*cut (4) at 3.00" per kit

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

November 10, 2010 12:36:37 PM

Work Order ID: 63714

Parent Item: DSI 9410-011

Parent Item Name: Step Modification

Start Date: 11/10/10 **Required Date:** 11/15/10

Start Qty: 8.00 **Required Qty:** 8.00

D3595	Manufactured	No	110	sf	0.0000	0.0833	0.6664	B41360 10/11/11

Rubber Cushion (per sq ft)
(D3595-200-300) Cut(2) at 2.00" X 3.00" as per dwg
D3595 (per kit)

MS21042L4	Purchased	No	110	Each	2,668.000	8	64	10/11/11

Nut

Location	Loc Qty	Loc Code	
ST300	2668		
113422	25		
114523	8		
115589	1535		64
115621	1100		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND DRAWING D350-591 REV. F

REF. CANADIAN STC: SH92-6

FAA STC: SH967NE **REFERENCE ONLY**

TO IMPROVE THE FIT OF THE D350-591-311/-312 STEPS, IT IS ACCEPTABLE TO INSTALL THE DSI 9410-011 KIT. INSTALL THE D2732-030 CUSHION (AFT CROSSTUBE) AND D3595-200-300 CUSHION (FWD CROSSTUBE) AS SHOWN IN FIGURE 1 IN PLACE OF THE D2856-400-720 ABRASION STRIP CALLED OUT ON DRAWING D350-591 REV. F.

FOR CUSTOMERS WHO HAVE PREVIOUSLY INSTALLED D2856-400-720 ABRASION STRIPS REMOVE THE ABRASION STRIPS IN ACCORDANCE WITH ICA-D350-591. PRIOR TO INSTALLING THE DSI 9410-011 KIT.

DSI 9410-011 KITS WILL BE INCLUDED WITH D350-591-311/-312 STEPS AT CHANGE 002 AND SUBSEQUENT.

QTY -041	PART NUMBER	DESCRIPTION
X	**DSI 9410-011**	**STEP MODIFICATION KIT**
4	D2732-030	CUSHION
2	D3595-200-300	CUSHION
8	AN4-15A	BOLT
16	AN960JD416	WASHER
8	MS21042L4	NUT (OR MS21042-4)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

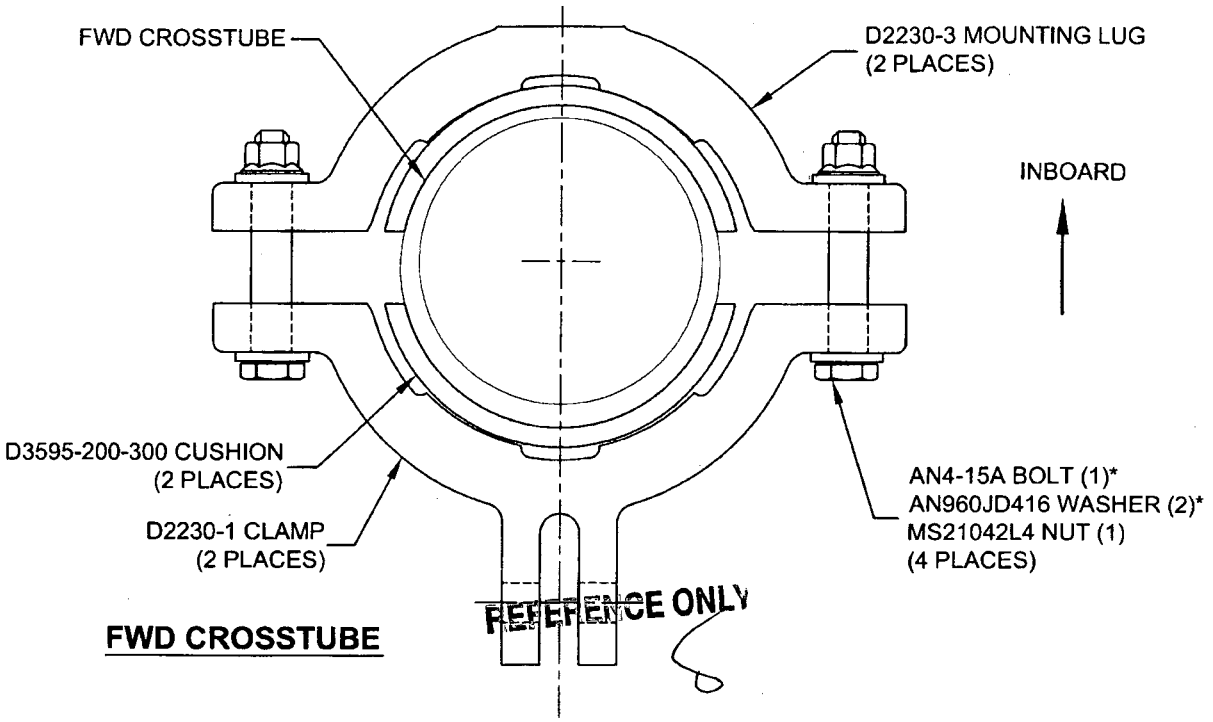
BY: _____
D. SHEPHERD (DE # 02)

DATE: 08.09.08
CERT. NO.: SH92-6
ISSUE NO.: 10

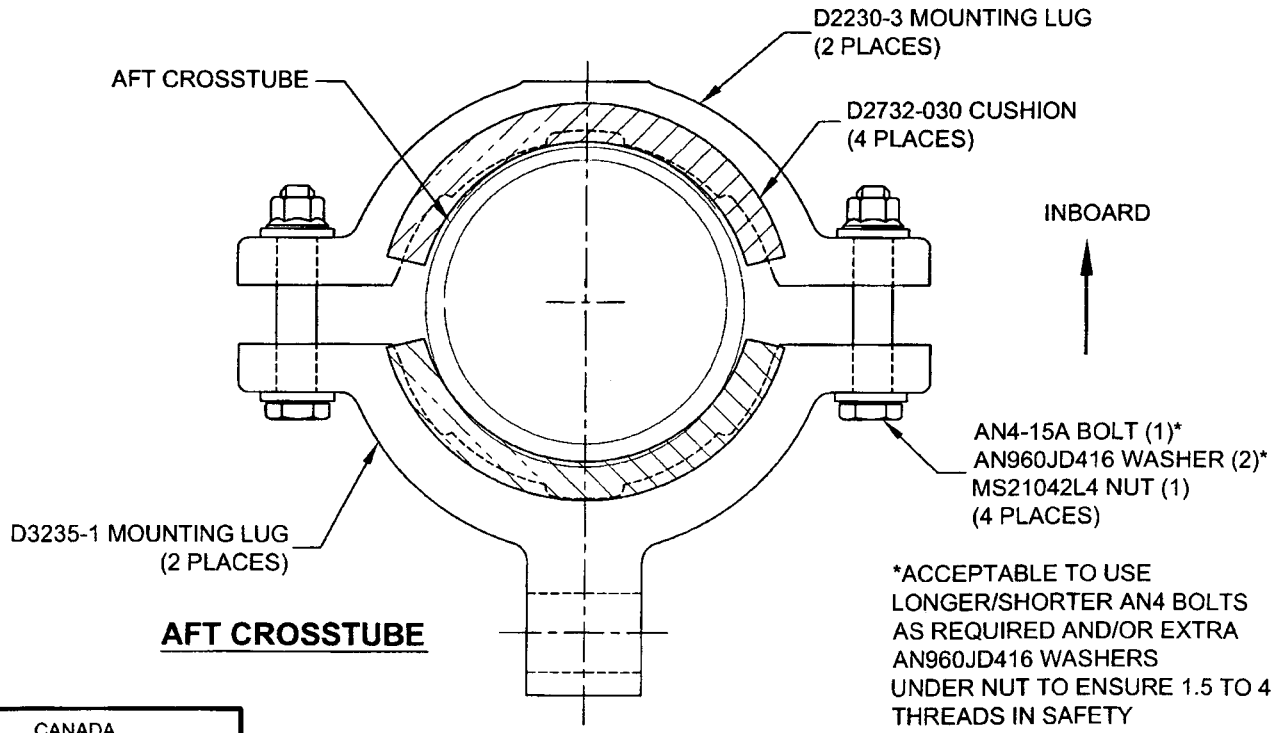
REV.	DESCRIPTION	BY	DATE
B	SHEET 1 DELETE REVISED P/L. (SEPERATE DSI KIT FROM MAIN KIT SEE NCR 08-082 FOR DETAILS)	AJS	08.09.08
A	NEW ISSUE	PH	08.03.27

DESIGN	AJS	**DART AEROSPACE LTD**	
DRAWN	AJS	**HAWKESBURY, ONTARIO, CANADA**	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9410	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP MODIFICATION KIT	NTS
DATE	08.09.08		

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FWD CROSSTUBE



AFT CROSSTUBE

*ACCEPTABLE TO USE LONGER/SHORTER AN4 BOLTS AS REQUIRED AND/OR EXTRA AN960JD416 WASHERS UNDER NUT TO ENSURE 1.5 TO 4 THREADS IN SAFETY

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: _____
D. SHEPHERD (DE # 02)

DATE: 08.09.08
CERT. NO.: SH92-6
ISSUE NO.: 10

FIGURE 1 - CLAMP/CUSHION INSTALLATION

DESIGN	AJS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. DSI 9410 REV. B SHEET 2 OF 2
MFG. APPR.	N/A	
APPROVED		TITLE STEP MODIFICATION KIT SCALE NTS
DE APPR.		
DATE 08.09.08		

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